

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025646**Date Inspected:** 30-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

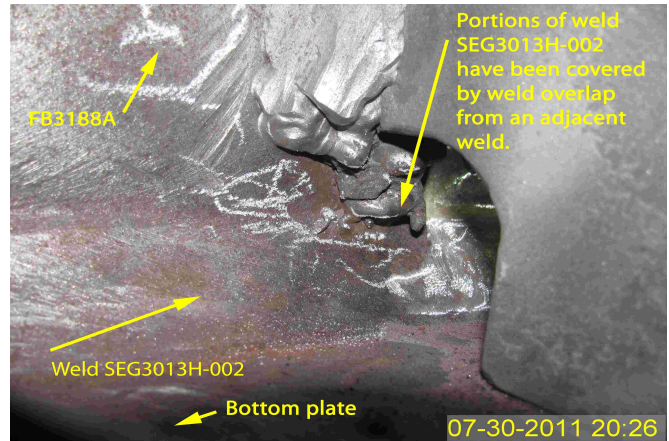
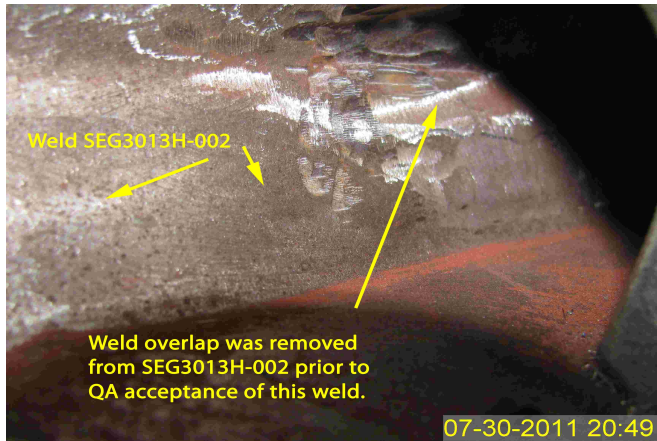
Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13 West welds as part of a special inspection program. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of welds: SEG3013X-474, SEG3013E-037 and SEG3013H-002. Note: Weld SEG3013H-002 is a complete joint penetration (CJP) weld and ABF performed magnetic particle inspections on the PP119-1500 side of the CJP weld and the PP119+1500 side of this CJP weld was covered with water and no MT inspections could be performed on this side of the weld. This QA Inspector observed one portion of this weld was visually rejectable due to an adjacent weld that overlapped onto the surface of weld SEG3013H-002. This QA Inspector informed ABF MT personnel and a ZPMC worker used grinder and rotary file to remove the overlap condition. Following completion of the grinding, this QA Inspector performed random visual and magnetic particle inspection of welds: SEG3013X-474, SEG3013E-037 and SEG3013H-002 (PP119-1500 side only) and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report and the photograph below.

WELDING INSPECTION REPORT

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Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
